

Date: Monday, 9/10/2007 1:31:57 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SUPPORT		
Job Number	: 34517B		Part Number	: D32782		
Estimate Number	: 10462		Drawing Number	: D3278 REV. C		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 9/10/2007 S.O. No. : N/A		Drawing Revision	: C		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 10/2/2007 Qty: 40 Um: Each		
Previous Run	: 34351B					
Written By	: <u>JL 07.09.11</u>					
Checked & Approved By						
Comment	: Est:A 04.04.19 New issue KJ/JLM					
	Est B 07.09.06 Rev C dwg EC Verified by: JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0" 
Comment: Qty.: 0.2454 f(s)/Unit Total : 9.8154 f(s) Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick <del>(M6061T6B1.000X02.000)2.000 x 1.125</del> Batch: <u>M105411</u> <u>JL 07/09/26</u>		
2.0	SHEAR	SHEAR 
Comment: SHEAR Cut blank: 2.00" x 1.00" x 2.550" long <u>JL 07/09/26</u>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-2 <u>8.5 07/00/03</u>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>8.5 07/10/03</u>		
5.0	QC8	SECOND CHECK 
Comment: SECOND CHECK <u>8.5 07/10/04</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/01/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/00/03	3.0	Part one have move in the vise, so the thickness of $.119^{+.005}_{-.004}$ was $.113$ at one end.	<input checked="" type="checkbox"/> B51011	SCRAP & Replace.	8.7 07/03/03 JUL 07-10-07	07/00/04 07/03/04 07-10-07	<input checked="" type="checkbox"/> 07/01/02	<input checked="" type="checkbox"/> 07/01/04
		R.C: operator didn't tight the vise enough.						

NOTE: Date & initial all entries

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Job Number: 34517B		Part Number: D32782
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1  <i>39x</i>
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		
7.0	POWDER COATING 	POWDER COATING <i>M105068</i> 
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 <i>41 07-10-05 39x</i>		
8.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>U 07-10-05</i> 
Comment: INSPECT POWDER COAT		
9.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>g1 07-10-05</i>		
10.0	QC21 	FINAL INSPECTION/W/O RELEASE  <i>38</i>
Comment: FINAL INSPECTION/W/O RELEASE <i>10/10/05</i>		
Job Completion 		<i>U 07-10-05</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34517B
Description: Support		Part Number:	D3278-2
Inspection Dwg: D3278	Rev: <i>PC 07.09.11 PC</i>		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.0985	✓			
0.359	+/-0.005	.358	✓			
0.015 0.609	+/-0.010	.615	✓			
0.250	+/-0.010	.252	✓			
1.480	+/-0.005	1.482	✓			
R0.125	+/-0.010	R.125	✓			
0.119	+0.005/-0.004	.120	✓			
2.439	+/-0.010	2.444	✓			
1.980	+/-0.010	1.981	✓			
R0.130	+/-0.030	R.130	✓			
Ø0.257	+0.005/-0.000	.260	✓			
R0.375	+/-0.010	R.375	✓			
0.875	+/-0.010	.876	✓			
0.500	+/-0.010	.501	✓			
R0.400	+/-0.010	R.400	✓			
R1.00	+/-0.030	R1.000	✓			
1.720	+/-0.010	1.720	✓			
R0.125	+/-0.010	R.0125	✓			
0.125	+/-0.010	.127	✓			

Measured by:	<i>sf</i>	Audited by:	<i>Onf</i>	Prototype Approval:	N/A
Date:	07/00/03	Date:	07/00/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	<i>sf</i>
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	<i>sf</i>

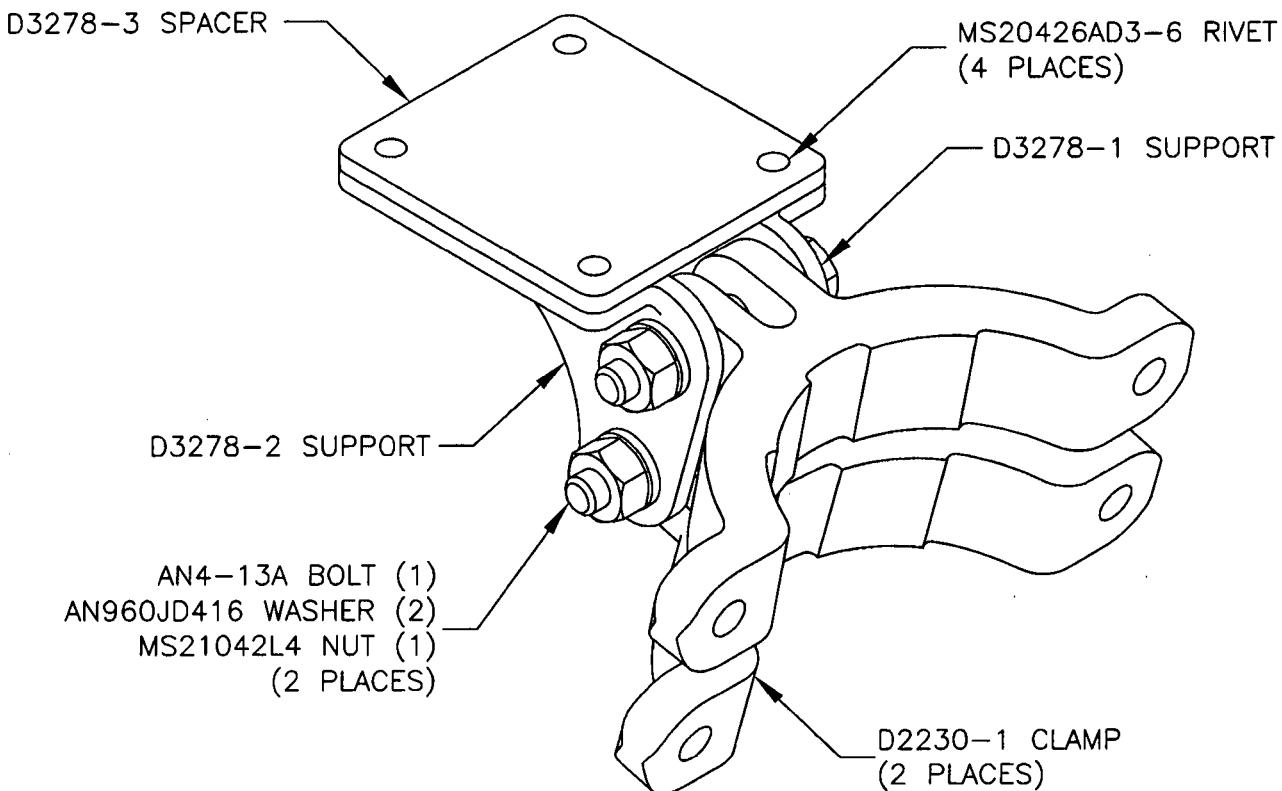


**DART**

DESIGN <i>QP</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>MM</i>	DRAWING NO.	REV. C
		D3278	SHEET 1 OF 3
DATE		TITLE	SCALE
07.07.24		SUPPORT ASSEMBLY	NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

**RELEASED**  
*07.08.08*

## D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

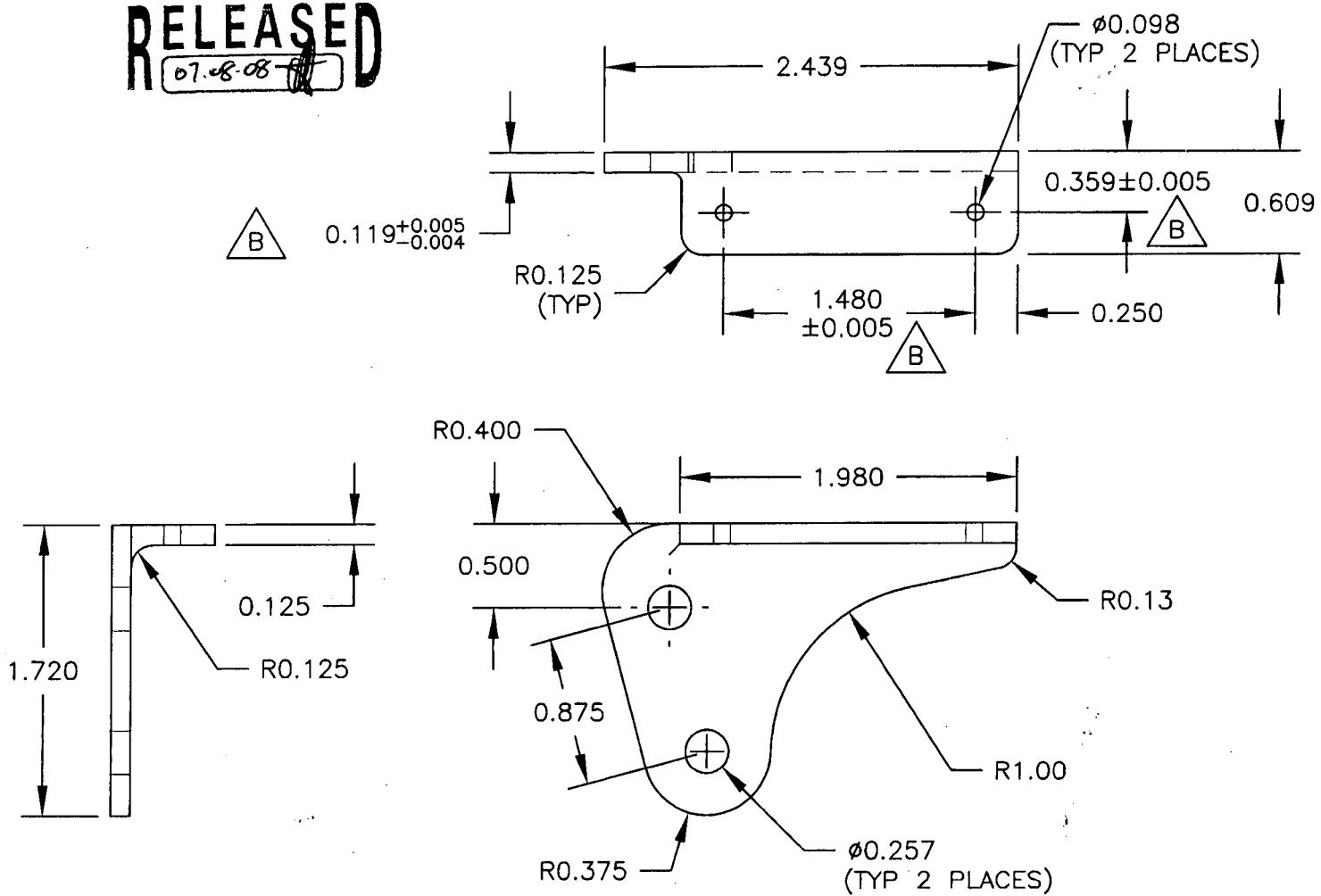
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CHECKED <i>BS</i>	APPROVED <i>TH</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

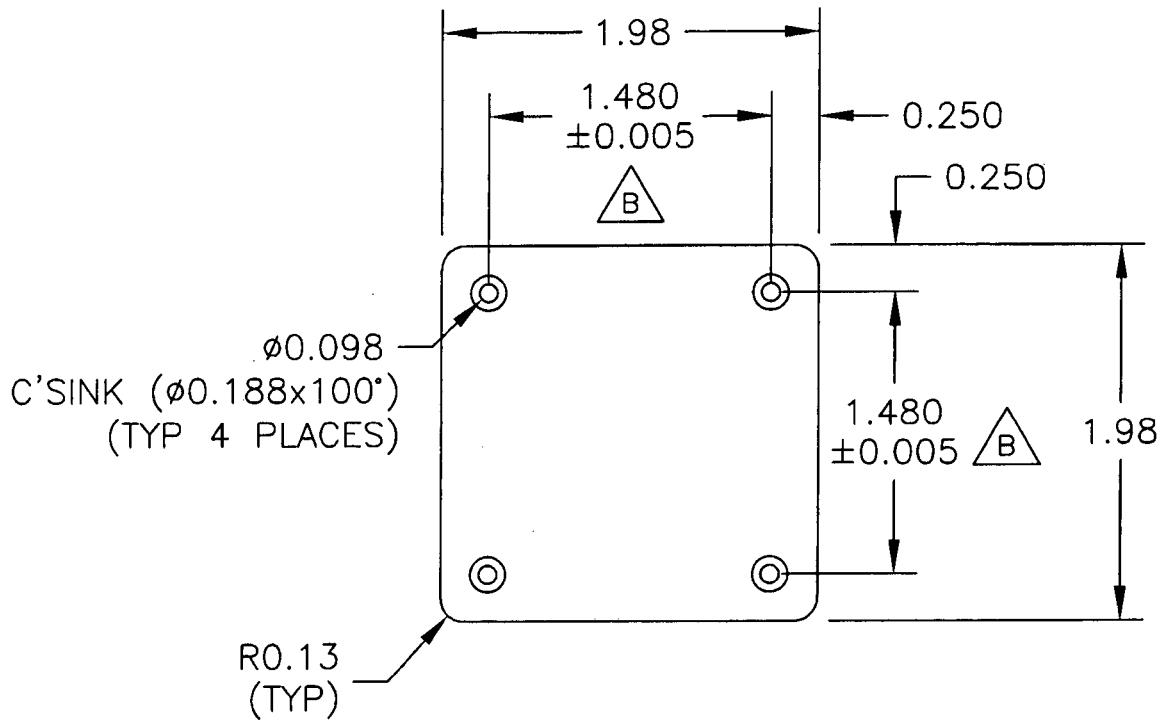
**RELEASED**  
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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CHECKED <i>BS</i>	APPROVED <i>HF</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

**RELEASED**  
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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